

SHENZHEN ATTEN TECHNOLOGY CO., LTD.

- Soldering Iron
- Hot Air Rework Station
- DC Regulated Power Supply
- Programmable Power Supply
- Soldering Station
- Multifunctional Maintenance System
- DC Switching Power Supply
- Fume Extractor

ATTEN



ZT-660-150G Automatic Feed Soldering Station User Manual

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MADE IN CHINA

SHENZHEN ATTEN TECHNOLOGY CO., LTD

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11/Product warranty

• Warranty regulations:

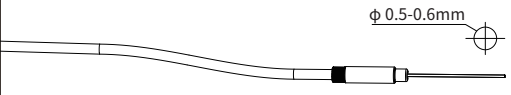
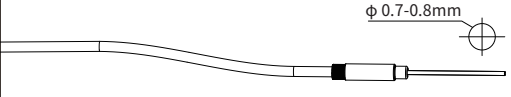
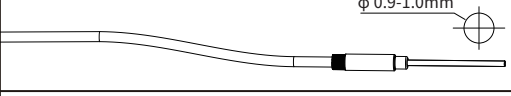
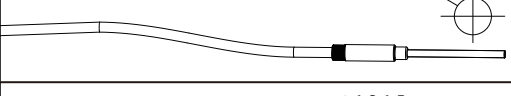
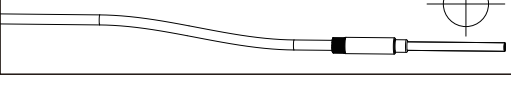
- ① The warranty period for this product starts from the date of purchase. During the warranty period, any malfunctions occurring due to the product's own quality issues can be serviced free of charge at our designated authorized repair center (or ATTEN) by presenting the original warranty card in accordance with the terms of this warranty card. Please keep your purchase receipt and this warranty card and present them together during repairs.
- ② During the warranty period, the following situations will incur paid repair services:
 - a. Inability to present a valid warranty card or valid proof of purchase.
 - b. The warranty card has incomplete or altered information, such as the purchase date or seller's name.
 - c. Damage caused by improper operation or failure to follow the instructions and precautions in the user manual.
 - d. Damage resulting from natural disasters or force majeure.
 - e. Damage caused by disassembly, repair, or modification of the product without manufacturer authorization.
 - f. Replacement of consumable or wear-and-tear parts (such as blades, heating elements, and accessories).
- ③ The warranty card must be completed in full by the distributor or user to qualify for the 24-month warranty period.
- ④ Please keep this warranty card safe. Lost cards will not be reissued.
- ⑤ Special cases will be subject to mutual agreement.
- ⑥ The final interpretation rights belong to ATTEN.

User Notice	Product Warranty Card
<p>This product is covered by a 24-month warranty from the date of purchase. In cases of product-related quality issues, ATTEN is responsible for free repairs when presenting this card and the purchase receipt.</p> <p>Note: When returning the product for repairs, the warranty card must be included, or else free repairs will not be provided. Thank you for your cooperation (please read the warranty policy for more information on warranty-related details).</p>	<p>Product Name: _____</p> <p>Product Model: _____</p> <p>Serial Number: _____</p> <p>Date of Purchase: : _____</p>


This product test result is qualified and met the technical standard.

10/Optional Accessories

• Guide Tube:

Model	Specifications	Illustration
ZP-D06M	Solder Wire Diameter 0.5-0.6mm	
ZP-D08M	Solder Wire Diameter 0.7-0.8mm	
ZP-D10M	Solder Wire Diameter 0.9-1.0mm	
ZP-D12M	Solder Wire Diameter 1.1-1.2mm	
ZP-D16M	Solder Wire Diameter 1.3-1.5mm	

• Soldering Iron Stand:



Model	Illustration
S-23	

• Soldering Tips and Heater Accessories:


- Please visit the ATTEN official website for more information or contact the local dealer and consult the manufacturer.

01/ Safety and Usage Precautions

- This product (including internal software) and its accessories are protected by relevant national laws. Any infringement on our rights will be subject to legal penalties. Users should voluntarily adhere to the relevant national laws while using this product.
- **Thank you for using our product. Before using this product, please carefully read this manual and take note of the warnings and precautions mentioned. Keep it in a safe place for future reference.**

 Warning	Improper use may result in death or serious injury.
 Caution	Improper use may result in personal injury or substantial damage to objects involved.

- We require users to have a basic understanding of everyday life and basic knowledge of electrical operations before using this product. For underage users, please use this product under the guidance of a professional or a guardian.

 Caution	To prevent injury, maintain a safe operating environment.
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- When using this machine, the following basic points must be adhered to in order to prevent electrical shocks, injuries to individuals, or potential hazards such as fires.
- To ensure personal safety, only use genuine or recommended parts and accessories; otherwise, serious consequences may occur.

 Warning
--

- **READ ALL INFORMATION BEFORE USE.**
- Power off when not in use or unattended. Place the soldering iron handle the iron stand, This tool must be placed on its stand when not in use.
- Keep this product away from flammable materials. When using, please inform other people in the area near the machine. Please do not touch the machine because of high temperature
- Do not apply to the same place for a long time.
- Be aware that heat may be conducted to combustible materials that are out of sight.
- Do not leave the appliance unattended when it is switched on.
- This appliance is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, or lack of experience and knowledge, unless they have been given supervision or instruction concerning use of the appliance by a person responsible for their safety.
- Children should be supervised to ensure that they do not play with the appliance.
- Cleaning and user maintenance shall not be made by children without supervision.
- If the supply cord is damaged, it must be replaced by the manufacturer, its service agent or similarly qualified persons in order to avoid a hazard.

 Caution

- Before connecting the power, please ensure that the voltage used by this product complies with the applicable voltage in your local area to prevent permanent damage to the machine. Before connecting the power, please ensure that the voltage used by this product complies with the applicable voltage in your local area to prevent permanent damage to the machine.
- When soldering, there will be smoke. Please use this product in a well-ventilated environment.
- When using this product, the temperature of the soldering tip can reach 80°C to 500°C (176°F to 932°F). Misuse may result in burns or fire.
- Users without relevant guidance, experience, or adequate knowledge preparation should refrain from using this product.
- Do not wet the soldering station. Avoid operating this product with wet hands or in a damp environment to prevent electrical shock.
- Do not immerse heater in liquids to prevent damage to heater.
- This product has grounding functionality. To ensure proper operation, make sure the power source is properly grounded when connecting the machine.
- When replacing parts or installing soldering tips, turn off the power and allow the soldering tip to cool to room temperature.
- Use original ATTEN parts when replacing product components.
- Do not engage in play or any dangerous activities while using the equipment, as this may lead to harm to yourself or others.
- Please do not use this product for purposes other than its intended function, as it may lead to damage to the machine or personal injury.
- Do not modify this product or its accessories, as this may void the manufacturer's warranty and damage the product.
- When plugging or unplugging the power cord, grip the plug body and avoid pulling or tugging the cord.
- Do not strike this product and its accessories with force during use, as it may damage the product.

Disclaimer

- We will take no responsibility for any personal injury or property damage caused by reasons other than the product quality problem, which may include force majeure (natural disasters, etc.) or personal behavior during the operation of this product.
- This manual is organized, compiled and released by SHENZHEN ATTEN TECHNOLOGY CO., LTD. According to the latest product features. We will not be responsible for further notice of the subsequent improvement of the product and this manual.

02/Packaging List



• Main unit x1



• Soldering Iron x1



• Soldering Iron Stand x1



• Solder Wire Stand x1



• Pedal x1



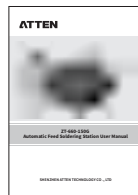
• Stand Cable x1



• Grounding wire x1



• Power cord x1



• User manual x1
• Certificate x1

09/Troubleshooting Guide

Warning

When checking for faults or cleaning the machine, it must be done by a professional. Always disconnect the machine's power and wait for the soldering iron to cool down to room temperature.

Issue	Possible Causes	Steps to Resolve
Cannot power on	Fuse is not installed or burnt out.	Check if the wiring is correct, confirm if the fuse is installed or shorted, and replace it with an original fuse as needed.
	Poor contact of the power cord.	Check if the power cord is damaged or deformed. If there is an issue, please contact your local dealer.
	Mainboard is damaged.	Please contact your local dealer.

Heat Core:T155-1.0IS			
Heater open E-1	Mode	Single	
	Use mode	Move	
	Speed	10.0mm/s	
	Length	5.0mm	
User Param	<input type="radio"/>	Interval	2.0s
Group ID	Default	RET-length	0.0mm

E-1: Open circuit in the heater
Troubleshooting: Replace the heater.

Heat Core:T155-1.0IS			
Sensor open E-2	Mode	Single	
	Use mode	Move	
	Speed	10.0mm/s	
	Length	5.0mm	
User Param	<input type="radio"/>	Interval	2.0s
Group ID	Default	RET-length	0.0mm

E-2: Sensor malfunction.
Troubleshooting: Check if the soldering iron and the heater are properly inserted

Heat Core:T155-1.0IS			
No zero crossing signal E-3	Mode	Single	
	Use mode	Move	
	Speed	10.0mm/s	
	Length	5.0mm	
User Param	<input type="radio"/>	Interval	2.0s
Group ID	Default	RET-length	0.0mm

E-3: No zero crossing signal.
Troubleshooting: The zero-crossing sensor is damaged, or the mains power frequency is incorrect, causing the sensor to be damaged.

Heat Core:T155-1.0IS			
Overcurrent protection E-5	Mode	Single	
	Use mode	Move	
	Speed	10.0mm/s	
	Length	5.0mm	
User Param	<input type="radio"/>	Interval	2.0s
Group ID	Default	RET-length	0.0mm

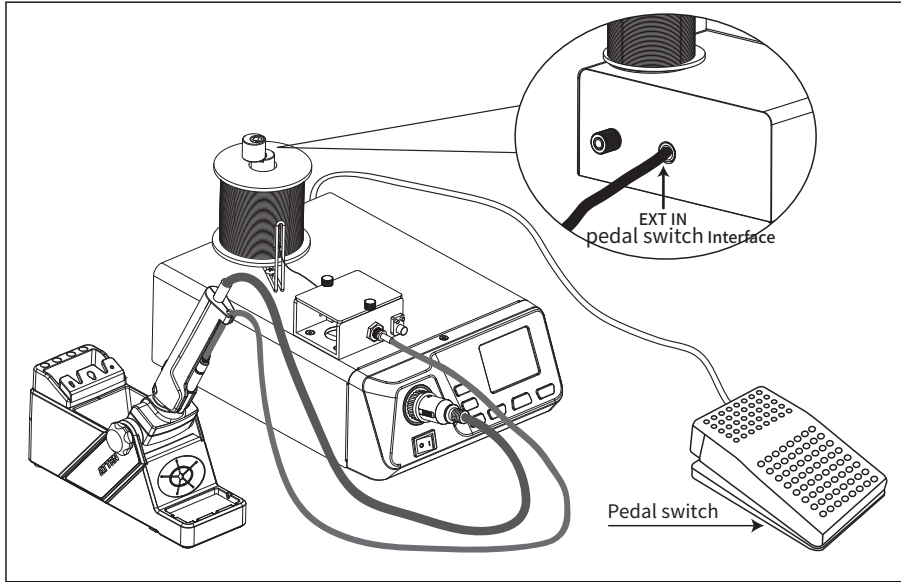
E-5: Overcurrent protection.
Troubleshooting: Short circuit inside the heater, it is recommended to replace the heater.

• After-sales contact

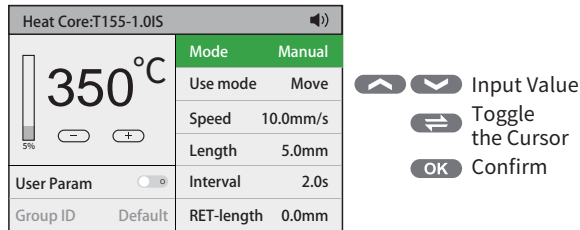
- If the machine fails, or cannot work normally due to unknown reasons, please contact the local dealer or manufacturer for consultation.
- After-sales service department Tel: 400-998-6633

08/External Pedal Switch Instructions

① Connect the pedal switch to the corresponding interface on the machine as shown in the diagram.



① Once the pedal switch is connected, various work parameters can be adjusted through the main interface (as shown on the right).



Note: After connecting the pedal switch, the automatic standby function is not available.

03/Specifications

• Technical Parameters

Main Unit:

Product Model	ZT-660-150G
Input Voltage	AC 220-240V~ 50/60Hz (AC 110-120V~ 60Hz)
Power	180W (±10%)
Temperature Range	80°C~500°C/176°F~932°F
Temperature Compensation	±50°C/±90°F
Temperature Unit	°C/°F, Default is °C
Temperature Adjustment Increment	Long press for quick adjustment, short press to adjust in increments of 1 unit
Quick Parameters	Supports customization of 10 sets of quick parameters
Temperature Lock	Supported
Electrostatic Grounding	Supported
Sleep Delay	Adjustable from 0 to 60 minutes (can be disabled, default is 15 minutes)
Language	Supports Chinese and English interfaces
Display	TFT color screen
Operating Environment	0°C~40°C, Humidity <85%RH
Dimensions	275x180x117mm
Weight (Main Unit)	≈4.1 kg

Automatic Feed Soldering Iron Parameters:

Product Model	ZP-155G
Product Model	≥150W
Heating Core Model	Standard: T155-1.0IS Optional: T155 series
Cable Length	100cm
Dimensions	183x21x30mm
Weight	≈0.14kg

• Packaging Parameters

Inner Box Packaging		Outer Box Packaging	
450(L)x330(W)x 215(H)mm	Gross Weight: ≈6.5KG	465(L)x345 (W)x455 (H)mm (2 unit/box)	Gross Weight: ≈14KG

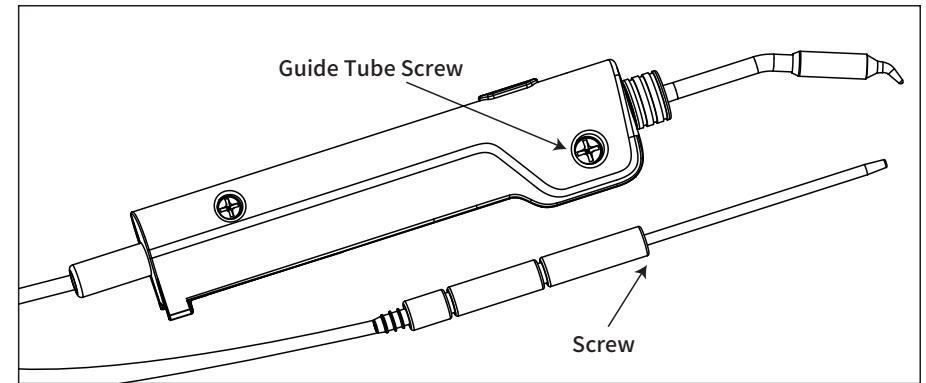
• Exterior Component Diagram (Front)



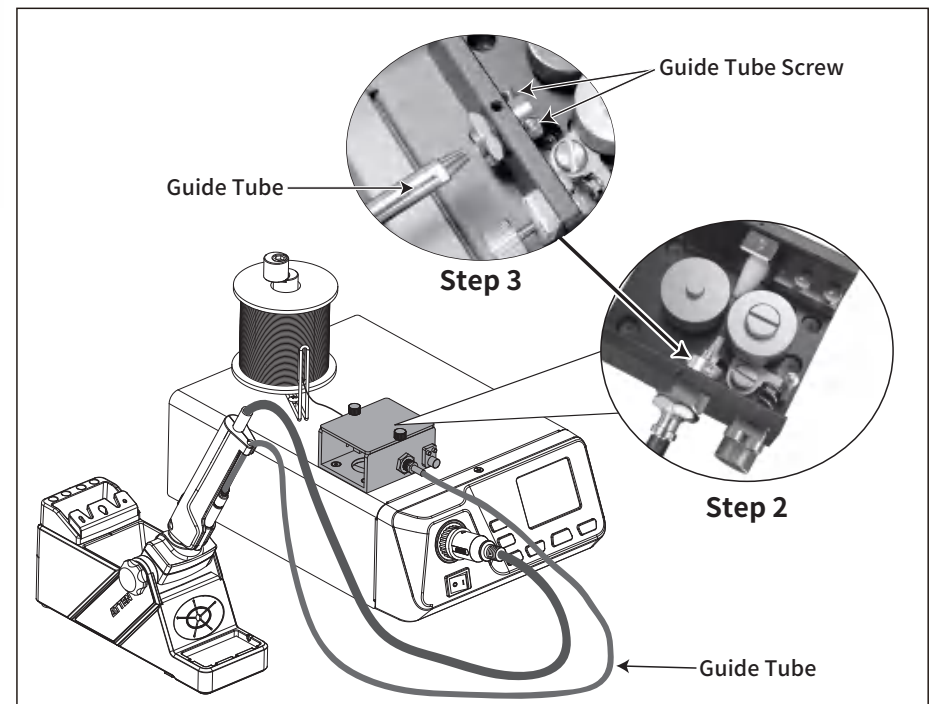
Serial number	Component description
①	Automatic Feed Soldering Iron
②	Solder Feed Box
③	Solder Wire Stand
④	Soldering Iron Stand
⑤	Power Switch
⑥	Soldering Iron Interface Indicator Lights: Red light: Not reached the set temperature or machine error; Green light: Reached the set temperature; Yellow light: Machine in standby or sleep mode.
⑦	Keypad area
⑧	USB interface
⑨	Display Screen

• Guide Tube Replacement:

Step 1: Remove the guide tube from the soldering iron after loosening the guide tube fixing screw on the side of the handle as shown.



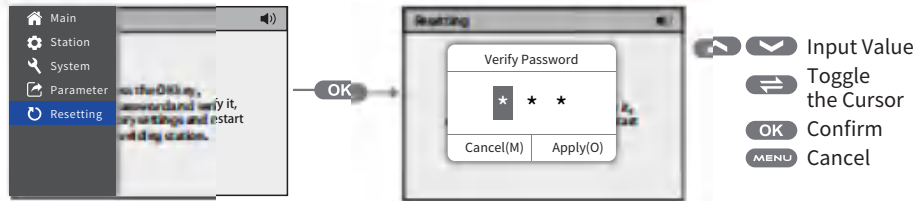
Step 2: Open the solder feed box and use a screwdriver to loosen the guide tube screw.



Step 3: Pull out the guide tube interface from the solder feed box, replace it with a new guide tube, and then tighten the guide tube screw.

• **Factory Reset:**

To restore factory settings, a password must be entered. After entering the correct password, the machine will automatically restart and restore the factory settings.



• **Exterior Component Diagram (Back)**

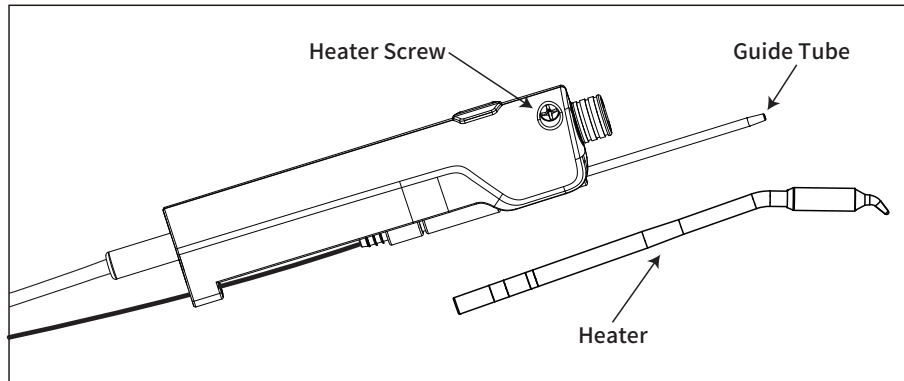


07/Soldering Iron Component Replacement

Warning

When replacing the heater and soldering tip, be sure to disconnect the machine's power and wait for the heater and handle to cool down to room temperature.


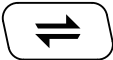




• **Heater Replacement:**



Loosen the fixing screw of the heating core on the side of the automatic tin feeding soldering iron, remove the heating core and replace it with a new heating core. (Note: when replacing the new heating core, it is necessary to adjust the heating core and the tin pipe to keep perpendicular and parallel before tightening the fixing screw)

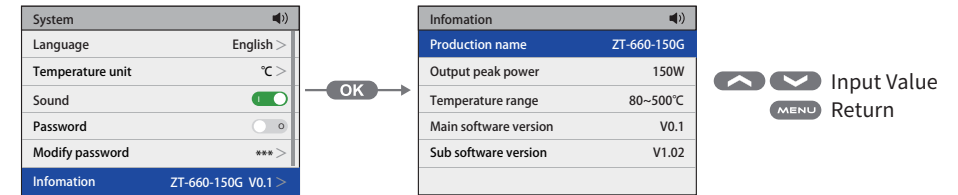
Serial number	Component description
①	Power Socket
②	EXT IN: 1. Use stand cable to number “④” connected in order to activate the sleep function. 2. Pedal Connector
③	Equipotential Connector
④	Use stand cable to number “②” connected in order to activate the sleep function.
⑤	Solder wire dragging button
⑥	Knob (Removable, Adjustable Angle)

• Function Key Description

Key	Function Description
	1. Analyze or explain all the options on the machine.
	1. Under the main interface status, the cursor can switch among the "Station Settings, Solder Feeder Parameter Settings, User Parameter Settings areas" (Refer to page 11 for main interface parameter adjustment). 2. On the parameter settings page, switch the cursor within the numerical settings.
	1. In the menu setting navigation bar, short press to enter the menu setting options; 2. In the menu setting page, short press to open and close the sound and quick temperature group; 3. In the menu setting page, short press to enter the parameter setting page; 4. In the parameter setting page, short press to confirm and save parameters.
	1. In the main interface or parameter setting page, short press to increase the parameter; 2. In the navigation bar page or menu setting page, short press to scroll up through the options; 3. On the main interface, when the quick temperature group is enabled, short press to switch between quick temperature groups.
	1. In the main interface, short press to display the menu setting navigation bar; 2. In the menu setting page, short press to return to the main interface; 3. In the parameter setting page, short press to return to the previous level
	1. In the main interface or parameter setting page, short press to decrease the parameter; 2. In the navigation bar page or menu setting page, short press to scroll down through the options; 3. In the main interface, after the quick temperature group is enabled, short press to switch between quick temperatures.

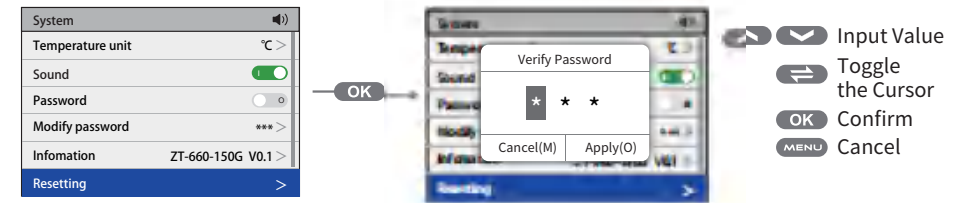
• Information:

In the system settings, select the Information function, and press "OK" to view machine information.



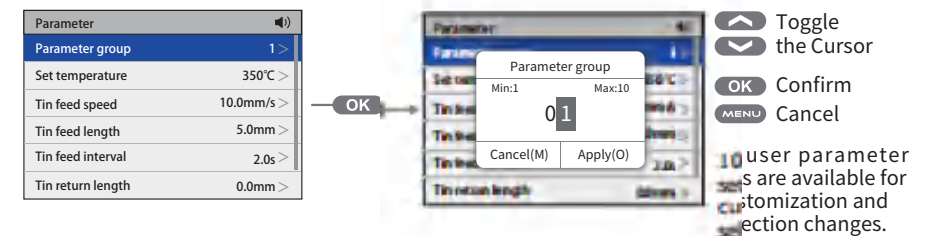
• Reset:

In the system settings, select the Reset function, and enter the machine password to reset the system settings.

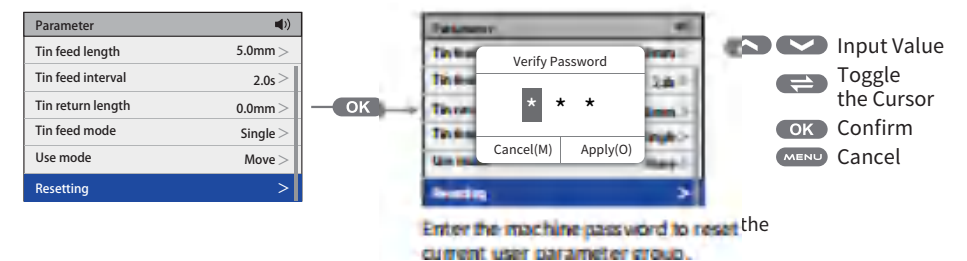


• User Parameters:

Customize 10 sets of user parameters, adjusting temperature settings, feeder speed, feeder length, feeder interval, feeder return length, and usage mode. Reset the current user parameter group by entering the machine password. (For detailed explanations of each parameter, refer to page 8.)

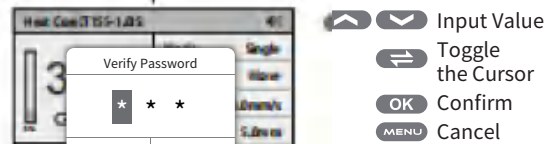
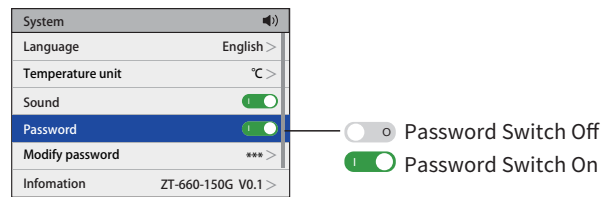


• User Parameter Group Reset:



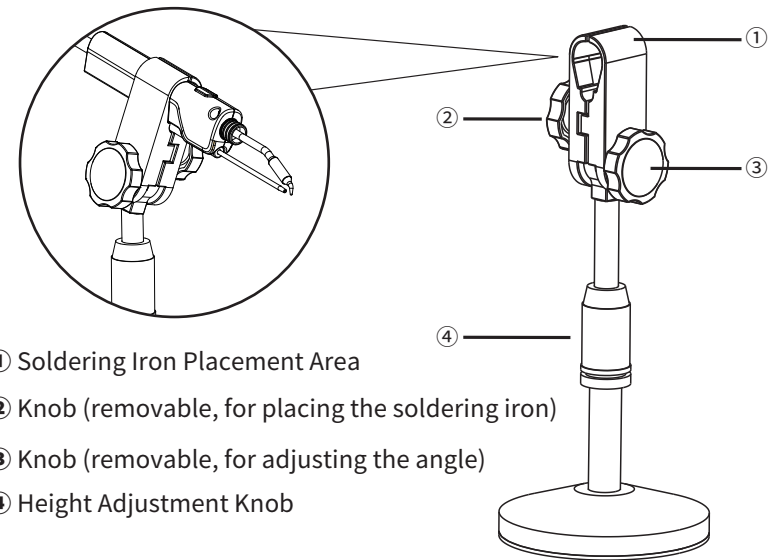
• Password Switch:

In the system settings page, select the Password Switch function and press "OK" to turn the password switch on or off.



When the password switch function is enabled, entering the menu interface requires inputting the machine password. (For setting the machine password, please refer to the "Password Modification" function.)

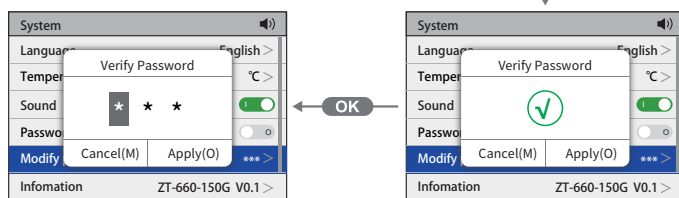
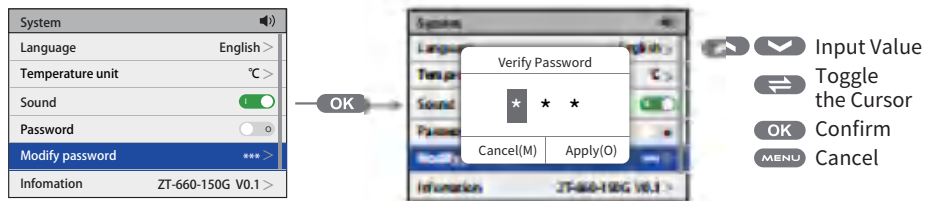
• Soldering Iron Stand Diagram:



- ① Soldering Iron Placement Area
- ② Knob (removable, for placing the soldering iron)
- ③ Knob (removable, for adjusting the angle)
- ④ Height Adjustment Knob

• Password Modification:

In the system settings page, select "Password Modification," then press "OK" to set a new password after validating the old password.

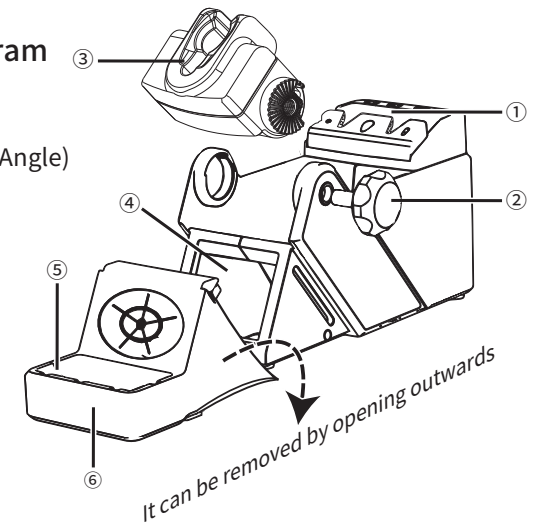


Enter the new password

Old password validation is correct

• Soldering Iron Stand Diagram

- ① Rear Holder
- ② Knob (Removable, Adjustable Angle)
- ③ Soldering Iron Holder
- ④ Cleaning Brass Wire
- ⑤ Cleaning Sponge
- ⑥ Removable Silicone Base

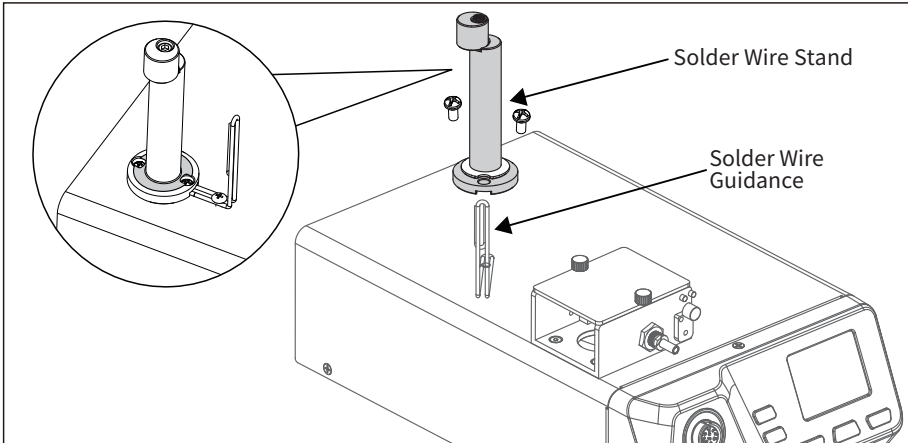


It can be removed by opening outwards

04/Installation Diagram of Machine Accessories

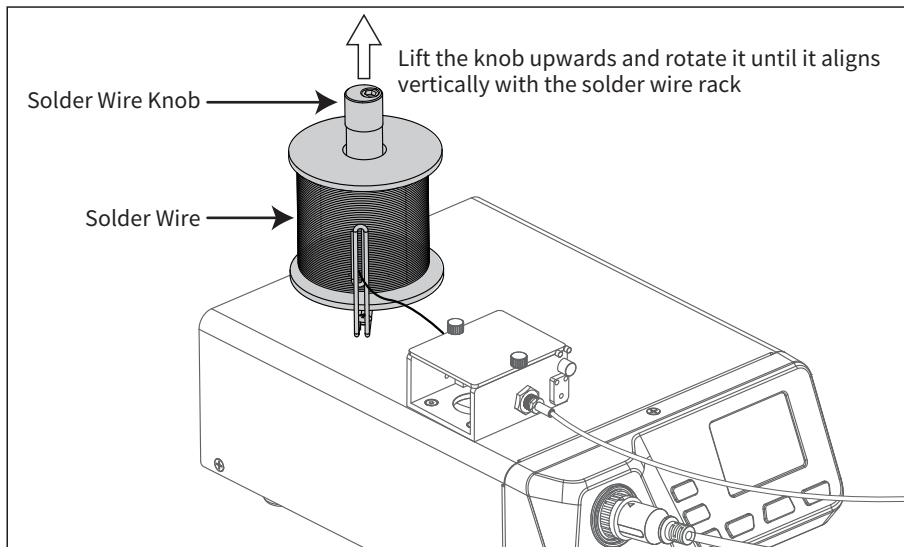
• Solder Wire Stand Installation:

Screw the tin wire shaft notch to the screw position as shown, and install the tin wire frame to the designated position of the top shell of the main engine with a screwdriver.
(The guide wire should be placed under the groove of the tin wire frame)



• Solder Wire Installation:

① Lift the knob of the solder wire rack upwards, rotate it until it aligns vertically with the solder wire rack, assemble the solder wire, and then rotate back the fixed knob.

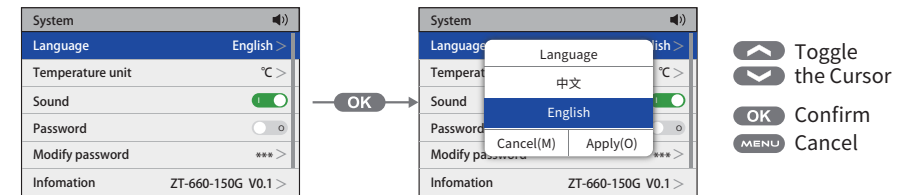


• System Settings:

System settings can set language, temperature unit, sound, password switch, change password, information, and reset function.

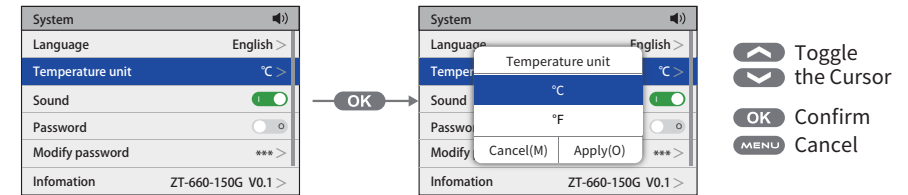
• Language:

Choose the language function under system settings to set the machine's language.



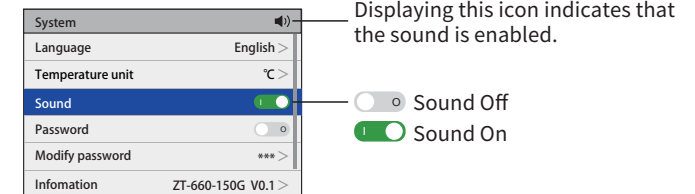
• Temperature Unit:

Choose the temperature unit function under system settings to set the temperature unit.



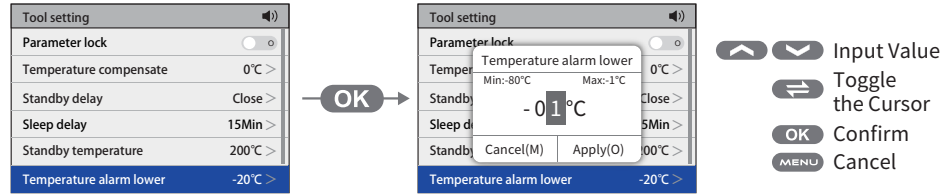
• Sound:

In the system settings page, select the sound function and press "OK" to turn the machine's sound on or off.



• Temperature Warning Limits:

In the station settings, selecting the temperature warning upper or lower limit function enables setting temperature warning parameters.

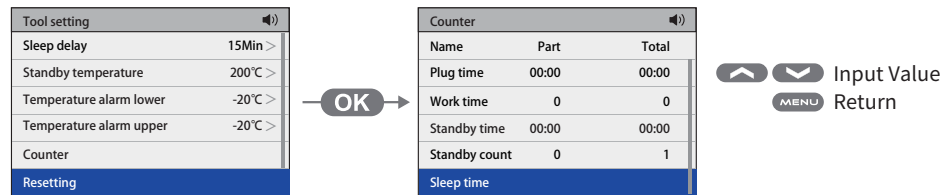


Note: Temperature upper and lower limits can restrict the maximum and minimum ranges of the machine's temperature settings.

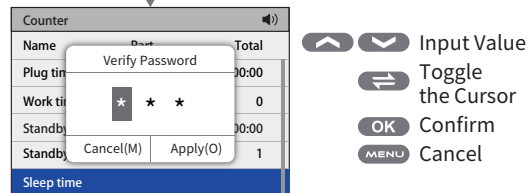
(Factory default temperature upper limit is 80°C/176°F, temperature lower limit is 10°C/50°F, adjustable range: -1°C to 80°C/-30.2°F to 176°F)

• Counter:

In the station settings, selecting the counter allows access to the current tool information.

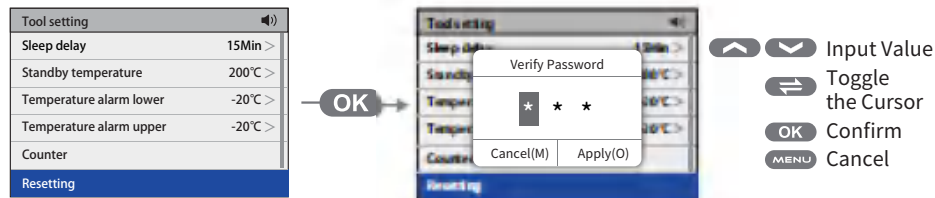


Note: The counter reset function requires the correct machine password for resetting. (The factory default password is "000". To set up the password, refer to page 17.)

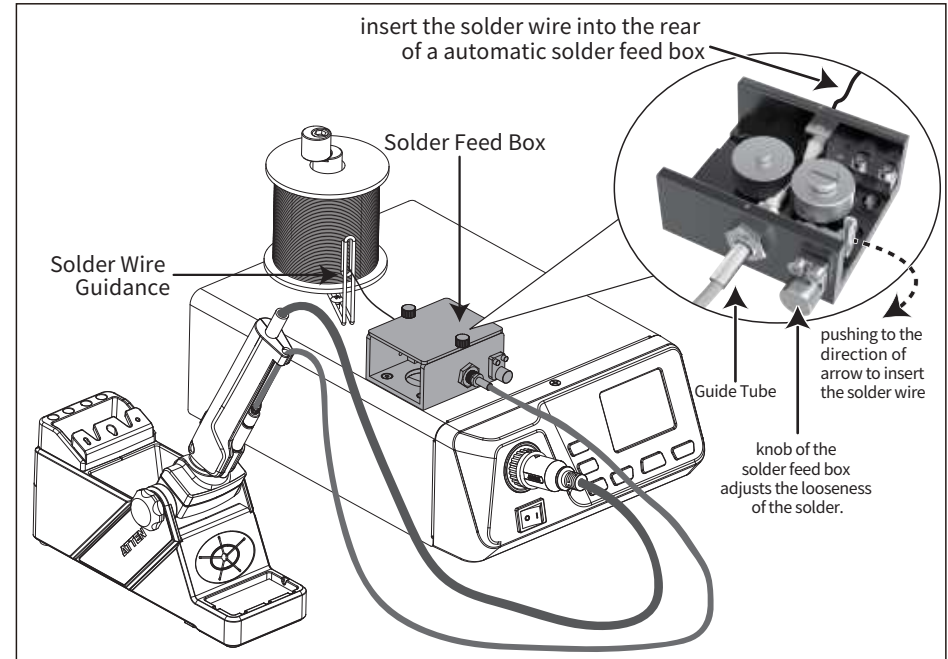


• Station Settings Reset:

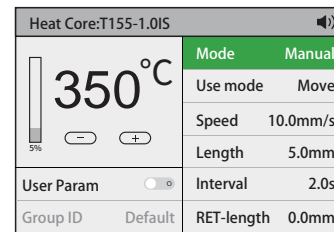
For the station settings reset, select the reset function under the station settings and enter the machine password.



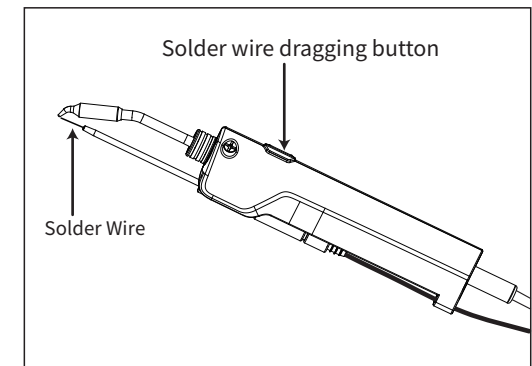
- insert the solder wire into the rear of a automatic solder feed box, pass the solder wire through the automatic soldering wheel, and finally into the guide tube.



- Enter the machine's main interface and change the solder feeding mode to manual (Figure 1-1). Long-press the automatic solder feeding button for the soldering iron (Figure 1-2) for continuous soldering.



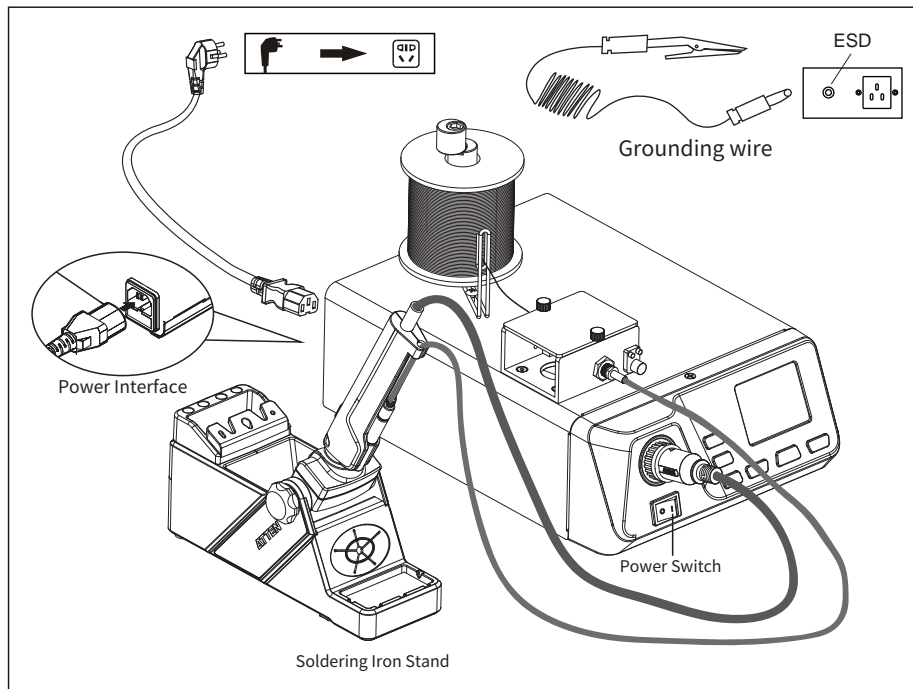
(Figure 1-1)



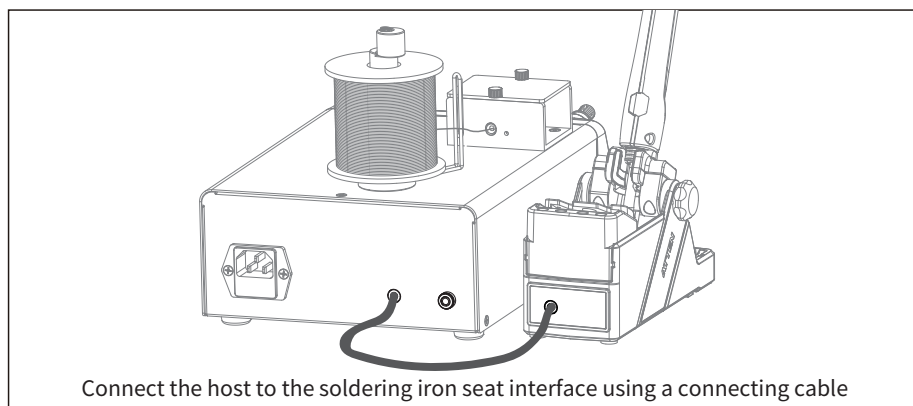
(Figure 1-2)

• Machine Connection:

- Connect the power cord, ground wire, and the guide tube of the automatic feed soldering iron to the corresponding interfaces on the main unit. (For installation of the automatic feed soldering iron's guide tube, please refer to ② on page 8.)



- In order to use the standby function of the handle normally, it is necessary to use the connection cable to connect the host to the corresponding interface of the soldering iron seat (as shown).



• Sleep Delay:

Selecting the Sleep Delay function in the station settings allows for setting the sleep delay parameter. (Adjustable from 1 to 60 minutes, can be turned off, default setting is 15 minutes at factory settings)

Tool setting

Parameter lock	○
Temperature compensate	0°C >
Standby delay	Close >
Sleep delay	15Min >
Standby temperature	200°C >
Temperature alarm lower	-20°C >

OK

Tool setting

Parameter lock	○
Temperature	Min:1Min Max:60Min 0°C >
Standby	15 Min Close >
Sleep delay	5Min >
Standby	Cancel(M) Apply(O) 100°C >
Temperature alarm lower	-20°C >

Input Value

Toggle the Cursor

Confirm

Cancel

Heat Core:T155-1.0IS

SLEEP	Mode	Single
Stop heating	Use mode	Move
Elapsed 00:00:21	Speed	10.0mm/s
5% Touch handler work	Length	5.0mm
User Param	Interval	2.0s
Group ID	Default	RET-length 0.0mm

Heat Core:T155-1.0IS

STANDBY	Mode	Single
Temp 200°C	Use mode	Move
Elapsed 00:00:22	Speed	10.0mm/s
5% Countdown 14:38	Length	5.0mm
User Param	Interval	2.0s
Group ID	Default	RET-length 0.0mm

Usage mode set to Moving mode

After the sleep countdown ends, the machine will stop heating and enter sleep mode. Picking up the soldering iron will resume normal operation of the machine.

Note: Only when the "Usage Mode" is set to "Moving Mode", After the machine goes into standby mode, and screen will display the sleep countdown.

• Standby Temperature:

In the Station settings, selecting the Standby Temperature function enables adjustment of the standby temperature parameter (adjustable within the range of 80°C to 200°C / 176°F to 392°F, with a factory default setting of 200°C / 392°F).

Tool setting

Parameter lock	○
Temperature compensate	0°C >
Standby delay	Close >
Sleep delay	15Min >
Standby temperature	200°C >
Temperature alarm lower	-20°C >

OK

Tool setting

Parameter lock	○
Temperature	Min:80°C Max:200°C
Standby	200°C
Sleep delay	Cancel(M) Apply(O)
Temperature alarm lower	-20°C >

Input Value

Toggle the Cursor

Confirm

Cancel

Heat Core:T155-1.0IS

STANDBY	Mode	Single
Temp 200°C	Use mode	Move
Elapsed 00:00:22	Speed	10.0mm/s
5% Countdown 14:38	Length	5.0mm
User Param	Interval	2.0s
Group ID	Default	RET-length 0.0mm

Usage mode set to Moving mode

Note: Only when the "Usage Mode" is set to "Moving Mode", After the machine goes into standby mode, and the heater will output according to the user-set standby temperature.

• Temperature Compensation:

can be adjusted within a range of $\pm 50^{\circ}\text{C}/\pm 122^{\circ}\text{F}$

- Input Value
- Toggle the Cursor
- Confirm
- Cancel

• Standby Delay:

In the station settings, select the Standby Delay function to set the standby delay parameter. (Adjustable from 1 to 30 minutes, can be turned off, default setting is off)

Usage mode set to Moving mode

- Input Value
- Toggle the Cursor
- Confirm
- Cancel

Note: Only in moving mode, when the host is connected to the connecting hole of the soldering iron seat, handle is placed on the soldering iron stand without any operation, the machine will enter standby mode according to the set standby delay parameter

(It will enter standby mode by default immediately, can be customized, Picking up the handle will resume normal operation.)

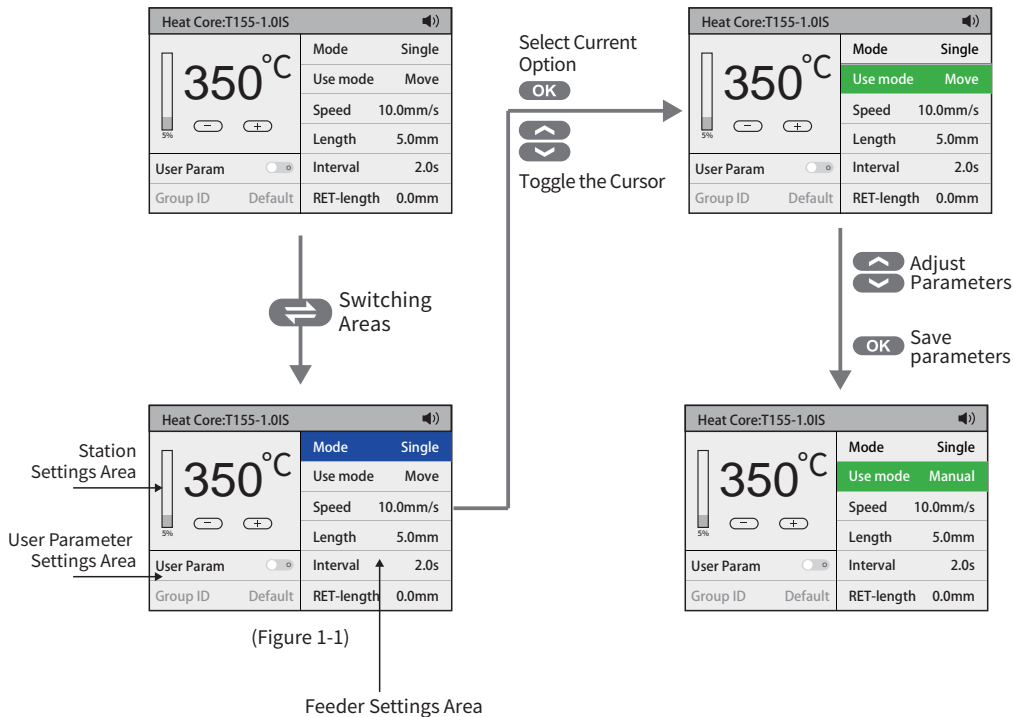
05/Main Interface

Serial Number	Heating Module Model
①	Current Heating Model
②	Current Real-Time Temperature Display
③	Sound Activation Icon (Not displayed when sound is turned off)
④	Heating Simulation Bar: Displays the current heating power intensity
⑤	Temperature "+" and "-" icons (Display in blue when selected, green when adjusting)
⑥	User Parameters (Icon displayed in green indicates enabled, displayed in grey indicates disabled)
⑦	Quick Parameter Groups (10 groups available, only selectable when user parameters are enabled)
⑧	Solder Feed Modes (Three available modes): <ol style="list-style-type: none"> 1. Single Mode: Short press the solder feed button will dispense solder once 2. Manual Mode: Long press the solder feed button will continuously dispense solder 3. Automatic Mode: The soldering iron dispenses solder automatically
⑨	Usage Modes (Two selectable modes): <ol style="list-style-type: none"> 1. Moving Mode: When the host is connected to the connecting hole of the soldering iron seat, handle is placed on the soldering iron stand without any operation, it will enter standby mode by default immediately (Menu settings can customize standby time) and the screen will display the standby status with the soldering iron temperature reduced to 200°C while maintaining heating output. 2. Fixed Mode: The machine works continuously without entering standby mode
⑩	Feeder Speed (Adjustable from 0 to 50mm/s)
⑪	Feeder Length (Adjustable from 0 to 250mm)
⑫	Feeder Interval (Adjustable from 0 to 10s)
⑬	Feeder Return Length (Adjustable from 0 to 10mm)

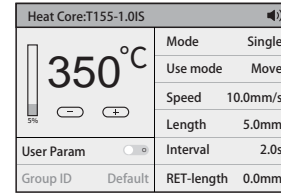
06/Function Introduction

• Main Interface Parameter Adjustment:

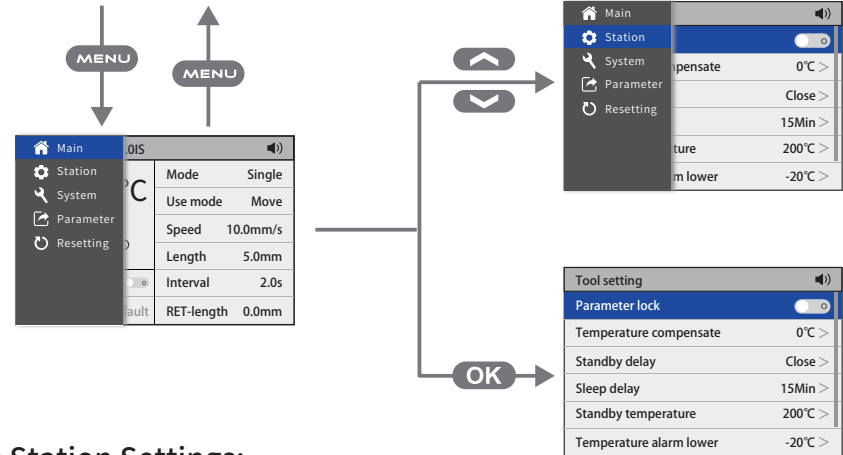
Short press the "↔" key on the main interface to select the Station Settings Area, Feeder Settings Area, or User Parameter Settings Area (as shown in Figure 1-1). Short press the "▲" or "▼" keys to switch the cursor within the selected area. Press "OK" to confirm the adjustment of the current parameter. Press "▲" or "▼" again to adjust the selected item's parameters. Finally, press "OK" to save the parameters.



• Menu Settings:



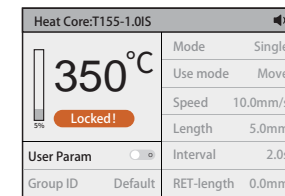
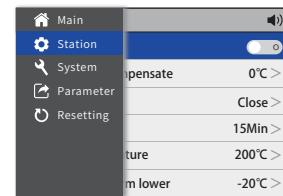
On the main interface, short press the "MENU" key to enter the menu page, Station Settings, System Settings, User Parameters Settings, and Factory Reset functions can be selected (as shown).



• Station Settings:

Station Settings allow configure parameter lock, temperature compensation, standby delay, sleep delay, standby temperature, resetting lower limit temperature warning, and resetting upper limit temperature warning parameters.

• Parameter Lock:



When parameter lock is enabled, the main interface will display "Parameter Locked," and the Parameter adjustment keys will become inactive.

